

Work Order ID 151377

Friday, September 23, 2016 2:49:00 PM

151377

Page 1

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 19" X 24"

Start Date: 9/9/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 9/23/2016 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 26 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	H

120 0.00

120

FLOW WATER JET

Waterjet

Memo

0.30

FLOW CNC Waterjet

Cut Blank as per D2432 File

12

on 16/09/26

130 0.09

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.90

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2432 Identify as D2432F
 3-Deburr

12

15

DAS 49 9-89

16/10/18
DAS 14 9-89
16/10/21

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.02

Quality Control

12

15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							DAS 44 9-89
150						12	0		16-10-23
QC	Memo	0.04							
Quality Control									
160	Identify as per dwg & Stock Location: <u>Sk</u>	0.00				12			OCT 24 2016
160									DAS 6 9-89
Packaging	Memo	0.02							OCT 21 2016
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									16/10/24
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

OCT 24 2016

Picklist Print

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Work Order ID: 151377

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Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 9/9/2016

Required Date: 9/23/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	334.0000	3.7	44.4			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

DC 16/09/26

Location

Loc Qty

Loc Code

MAT

320

m135497

320

MAT018

14

m135013

14

46

DART AEROSPACE LTD		Work Order: 151377
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

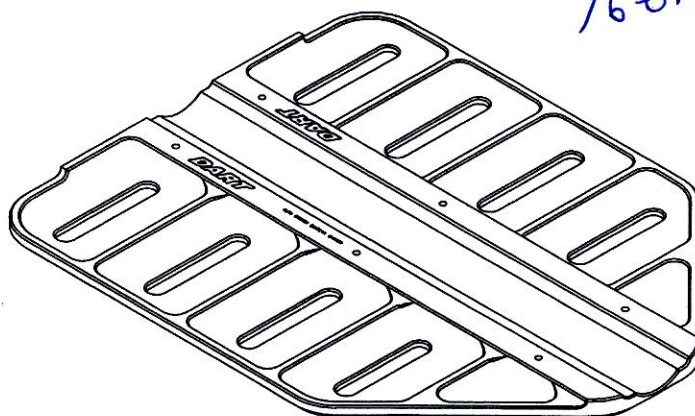
FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055 x 45°	/		vern	mark-05
B	0.200	+/-0.030	0.195	/		"	
C	0.25 x 45°	+/-0.030	0.25 x 45°	/		"	
D	R0.250	+/-0.030	0.250	/		RG	
E	0.250	+/-0.010	0.250	/		vern	mark-05
F	0.625	+/-0.030	0.630	/			
G	0.375	+0.030/-0.010	0.395	/			
H	0.950	+/-0.030	0.958	/			
I	19.000	+/-0.030	19.000	/		tape	
J	Ø0.260	+0.005/-0.000	0.260	/		vern	mark-05
K	Ø0.93	+/-0.030	0.929	/		"	
L	0.30	+0.030/-0.000	0.318	/		Depth	GA-08
M	23.750	+/-0.030	23.750	/		tape	
N	2.000	+/-0.030	2.022	/		vern	mark-05
O	0.38	+/-0.030	0.380	/		"	
P							
Q							
R							
S							
T							
U							
V							

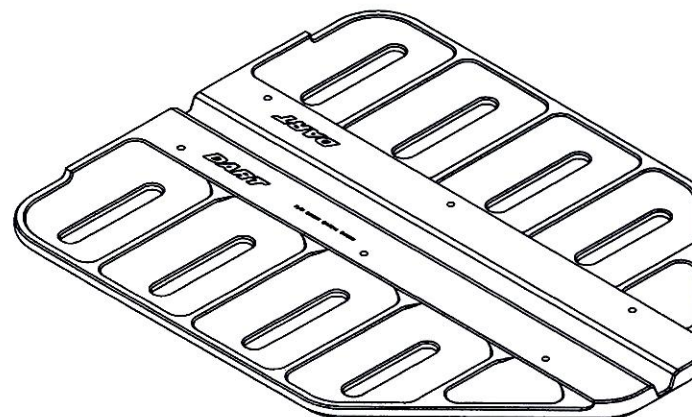
Measured by: 9-89	Audited by: 44	Preliminary Approval:
Date: 16/10/19	Date: 16-10-23	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151377 MJS
16-09-26



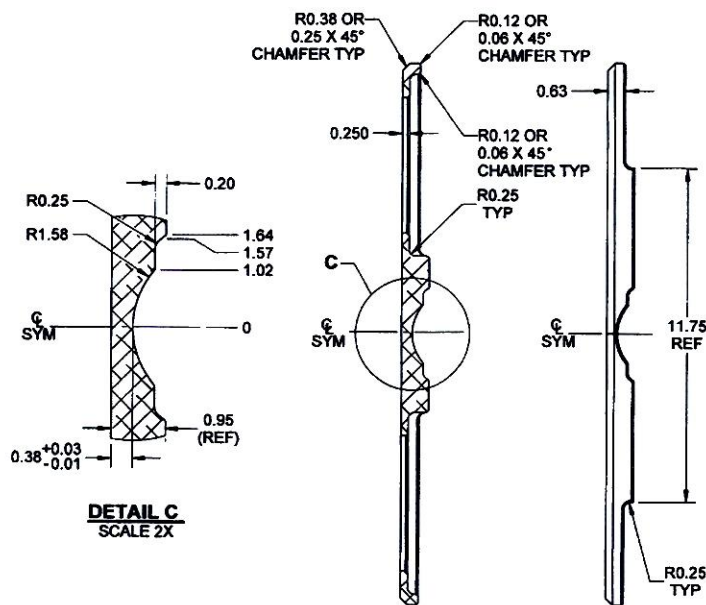
D2432F BEARPAW



D2432-3 BEARPAW

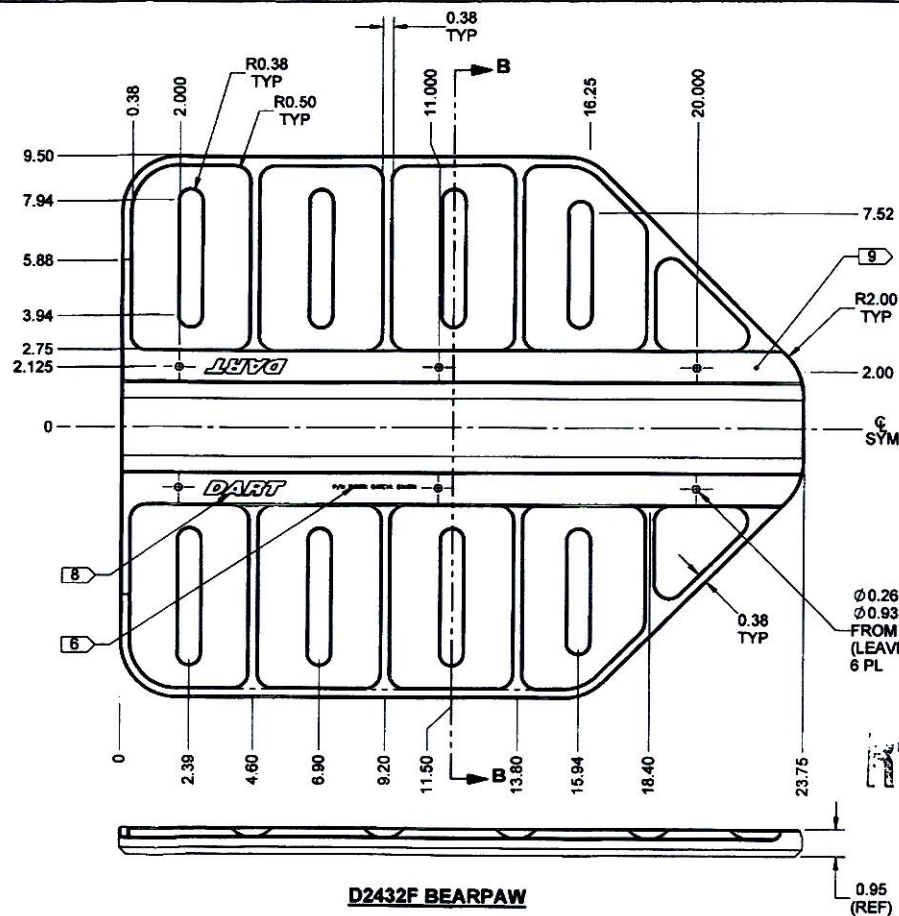
RELEASED
2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV F FOR DETAILS	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F PIN	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>AJS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>at</i>	D2432	SHEET 1 OF 3
APPROVED	<i>10</i>	TITLE	SCALE
DE APPR.	<i>10</i>	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DETAIL C
SCALE 2X

SECTION B-B



D2432F BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	BT	D2432	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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